

Date: Tuesday, 07/04/2009 3:21:29 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number :	47052		
Estimate Number :	13433		
P.O. Number :		Part Number :	PB674300115 GN
This Issue :	07/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.7
First Issue :	07/04/2009	Project Number :	N/A
Previous Run :	45041	Drawing Revision :	B1
		Material :	
Written By :		Due Date :	14/04/2009
Checked & Approved By :	MF 09-04-08		
Comment :	Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PB6743001257	Inner Tube
-----	--------------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Inner Tube

batch: B43070 = 1X

Sp 09.04.20

2.0	PB6743001249	Inner Tube Bushing
-----	--------------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Inner Tube Bushing

batch: B44984 = 1X

Sp 09.04.20

3.0	PB6743001253	Gusset
-----	--------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

batch: B44983 1X

Sp 09.04.20

4.0	PB6743001254	Gusset
-----	--------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

batch: B44982 1X

Sp 09.04.20

5.0	PB674300171	PB67-43001-71
-----	-------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-71

batch: B41512 = 1X

Sp 09.04.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:29 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: .47052

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

12

SP 09.04.20

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09/04/20 (X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorlaba (X)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HELICAL INSERT

MI11064

SP 09.04.21

①

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

SP 09.04.21

①

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorlaba (X)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1/175

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

SP 09.04.21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:29 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 47052

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M18144

11:00

320

11:30

BR 09-04-21

①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Al

09-0-1-21

(X)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

20 Degree Cover Plate

batch: B41513

EP09/05/06

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PB67-43001-83

batch: B47042

EP09/05/06

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

batch: M111425

EP09/05/06

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

batch: M111117

EP09/05/06

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

EP09/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:29 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 47052

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/05/06 (*)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MISC

09-05-06

(1)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06

Job Completion



MF
09-05-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

